

Date: Wednesday, 3/8/2006 10:38:34 AM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: OUTLET ADATER PLATE
Job Number	: 26124 -2		
Estimate Number	: 12161		
P.O. Number	: NIA	Part Number	: D34751
This Issue	: 3/8/2006 S.O. No. : NIA	Drawing Number	: D3475 REV A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: NIA Type : PURCHASED PARTS	Drawing Revision	: A
Previous Run	: NIA	Material	: NIA
Written By	: SEE COMMENT BELOW	Due Date	: 3/31/2006
Checked & Approved By	: 06.03.08	Qty:	10 Um: Each
Comment	: Est Rev:A New Issue 06-02-02 JLM		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PG	PURCHASING
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Comment: Issue P/O: 00000768 06/03/09  
 E-mail or Ship DXF file to vendor  
 Laser cut flat pattern as per Dwg D3475  
 Possible supplier: Ind. Laser  
 Material release note is required.

2.0	D34751F	OUTLET FLAT PATTERN
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 6.0000 Each(s)  
 FLANGE PLATE

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1  
 Receive & Inspect For Transit Damage  
 Ensure material certification is attached

C 06/03/21

(10)

4.0	QC6	DIMENSIONAL CHECK
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Comment: DIMENSIONAL CHECK

06/04/22  
 (9/10)

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL &amp; MEDIUM FAB RESOURCE 1

1-Deburr if necessary.

2-Form as per Dwg D3475 using Dt8847 A&amp;B on press.

SB 06/04/12 B

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
		One taken for template		Dec 03 28 1		1 Basen	Dec 03 28

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☐ No ☒ DQA: ☒ Date: 06/04/18  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



Date: Wednesday, 3/8/2006 10:38:35 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: OUTLET ADATER PLATE

Job Number: 26124

Part Number: D34751

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

AB 06-04-16

8

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: GA

SB 06/04/12

8

Job Completion



Level 21 inspection SP 06/04/18

LL 06-04-13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries







T-726 P.007/015 F-587

INDUSTRIAL LASER P.O. - 110860 S.O. - 374786 ITEM 01 - 3 SHIS


604-946-453. ATN; PETE

3/17/66

CONTINUED ON NEXT PAGE





		<b>AK Steel Corporation</b> <b>Metallurgical Test Report</b> <b>Coshocton Works</b> <b>Coshocton, OH 43812</b>		Page 2				
		Lot# No. 7410672 BRN No. 7410672						
C O S T R U C T I O N S 	INTEGRIS METALS PO BOX 360 MINNEAPOLIS, MN 55440		S H I P T O	INTEGRIS METALS 305 "B" STREET AUBURN, WA 98001				
				MILL ORDER NO. 272345-0191 PROCESSOR ORDER NO. 427136-01 BUYERS ORDER NO. 427136-01 PART NO. 74231497 ENGLISH UNITS - PRODUCT - METRIC UNITS .9175 NOM 48400 X COIL				
PARENT COIL ID	POS (W/T)	DIR (L, T, D)	COND	ASTM A 287 FRACTURE	BEND 180 IT			
0549919-02	T		ASTM	PASS	PASS			
PARENT COIL ID	POS (W/T)	DIR (L, T, D)	COND	%ELONG 2 INCH MEASURED	TENSILE STRENGTH (KSI)	Y.S. 3% OFFSET (KSI)	ROCKWELL HARDNESS T <sub>01</sub>	ROCKWELL HARDNESS Front
0549919-02	F	T	ASTM	71.0	92.8	33.1	B 72	B 74
PARENT COIL ID	POS (W/T)	DIR (L, T, D)	COND	BEND 180 IT				
0549919-02	F		ASTM	PASS				
<p>THE CHEMICAL ANALYSIS AND PHYSICAL OR MECHANICAL TESTS REPORTED ABOVE ARE CORRECT AS CONTAINED IN THE RECORDS OF THE CORPORATION.</p> <p>ALL TESTING IS DONE IN ACCORDANCE WITH AISC STANDARDS UNLESS OTHERWISE NOTED.</p> <p>AK Steel Corporation      MAY 17 2006</p> <p>WITNESSED: <i>Steve Rayson</i>      DATE 05/17/2006 TIME 10:42 PM</p> <p>APPLICATION NUMBER</p>								





## MATERIAL TEST REPORT

From: NORTH AMERICAN STAINLESS CANADA, IN  
740 IMPERIAL ROAD NORTH

Page : 1  
Heat/Lot : 86K8  
TIN : B42748

Sold To: INTEGRIS METALS, LTD.  
7910 40TH STREET SE  
CALGARY, AB T2C2Y3

Ship To: \*\*\*CUSTOMER PICKUP\*\*\*  
4375 14TH STREET NORTHEAST  
CALGARY  
ABT3E7A9

### Vendor Information

Cust PO #: 406824

Cust PO DT: 11/03/05

### Specifications

STAINLESS STEEL SHEET, COLD ROLLED, ANNEALED AND PICKLED.  
ASTMA240/04a 480/04a, 666/03, ASME SA240/04-A05, 480/04-A05, SA666/04  
Q08766D-A X 1/8 PRM, AMS5513H X MRK&FIN, MIL5059D, AMD3, X CROWN MEAS  
CORROSION: ASTM A262/02aE; 180Bend-OK  
Buyer Part: 4288441  
304 2B 1305 IN 48 IN 96 IN  
Country of Origin: UNITED STATES

### Mechanical Tests

		UOM	L	O		UOM	L	O
Yield Strength - 0.2% Offset	40	KSI	F	TRANSV				
Tensile Strength (UTS)	93.3	KSI	F	TRANSV				
Rockwell B	85		F	TRANSV				
Pct Uniform Elong 2 In/50mm	57.01	PCT	F	TRANSV				
Rockwell A	85		T	TRANSV				

### Chemical Composition

C Carbon-Pct	.059	CR Chromium-Pct	18.360
CU Copper-Pct	.342	MN Manganese-Pct	1.643
MO Molybdenum-Pct	.285	N Nitrogen-Pct	.037
NI Nickel-Pct	8.150	P Phosphorus-Pct	.029
SI Silicon-Pct	.289		

### Comments





# MATERIAL TEST REPORT

From: NORTH AMERICAN STAINLESS CANADA, IN  
740 IMPERIAL ROAD NORTH

Page : 2  
Heat/Lot : 86K8  
TIN : B42748

Material free from mercury contamination. No weld repairs.  
EN 10204 3.1 PED 97/23/EC Annex1, Para. 4.3 Q08763F Cond A  
This document certifies the material has been tested in  
accordance with applicable specifications described herein  
and has met those requirements.

QA by ERIC HESS 02/01/2006

## Miscellaneous Data

GUKLEPH, ONNE K123  
Control #: 50C60214  
Part #: 74271441  
.135 X 48 X 96

Date: 03/17/06

SOLD TO: INDS. LASER

TO 110880

S/P 90-374786 - 02

*Eric Hess* 3/17/06

The Chemical Analysis and Mechanical Test  
data was received via EDI from the above  
mentioned vendor.

INTEGRIS METALS, LTD.

